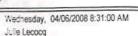


Qty:



Process Sheet

0		-		
C	ust	οп	ıeı	

: CU-DAR001 Dart Helicopters Services

Type

Job Number

: 39685 - B

Estimate Number

: 10387

P.O. Number

This Issue

: 04/06/2008 S.O. No. :

Prsht Rev. : NC

First Issue Previous Run : // : 39390

Written By

Checked & Approved By

Comment

C : Est.

08.03.19

02.11.26

Re-format Ec verified by DD

: MACHINED PARTS

Est Rev:D Added priming as per Rev B 07-04-30 JLM

Reformat, Added P/O KJ

: D29401 Part Number

Drawing Number

Drawing Name

: N/A Project Number

: B **Drawing Revision** Material

Due Date

: 27/06/2008

: 03.250 SUPPORT

D2940 REV B

10

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description: D2940-1 TURNING DETAIL

1.0

DSK081

Comment: Qtv.: 0.5000 Each(s)/Unit

Total:

10.0000 Each(s)

D2940-1 TURNING DETAIL

Batch: 3 3968

2.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS

1- Machine as per Folio FA079

2- Tumble & Deburr

3.0 QC1 INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET



4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

5.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3 *******Mask Inside Surface as per Dwg D2940*********

START TIME:

OVEN TEMPERATURE: FINISH TIME:

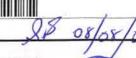


04/08/05 m-h













sday, 04/06/2008 8:31:00 AM CU-DAR001 Dart Helicopters Services

Process Sheet

Drawing Name: 03.250 SUPPORT

ber: 39685

Part Number: D29401

Machine Or Operation:

Description:

SPRAY PAINTING

SPRAY PAINTING

Comment: SPRAY PAINTING

Prime inside surface as per Dwg D2940 and QSI 005 4.3.

7.0

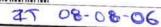
INSPECT POWDER COAT/CHEMICAL CONVERSION

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8.0

PACKAGING 1

PACKAGING RESOURCE #1





Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: LG

9.0

QC21

Comment: FINAL INSPECTION/W/O RELEASE



Job Completion



Le 08.08.06

DART AEROSPACE LTD	Work Order:	39685
Description: Ø3.250 Support	Part Number:	D2940-1
Inspection Dwg: D2940 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

			X First	Article	Proto	type		
	Record Actual Dimensions							
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
	-			HAAS Section	n			
AA	0.240	0.260		0.250	0.250	0 25	0 0.250	0.250
AB	0.490	0.510		0.500	0.500	0.50	0 0.50	0 0.500
AC	0.140	0.160		0.153	0.153	0.15		- 0.15
AD	3.510	3.530		3.518	3.5/8	3.51		
AE	1.633	1.673		1.661	1.661	1.654	1 1,654	1 1.652
AF	1.493	1.513	7	1.510	1,510	1,504	1 1.503	1.503
AG	0.040	0.060		0.051	0.051	0.05	4 0.049	
AH	0.188	0.193		0. 188	0.188	0.188	0.188	0.188
Al	0.140	0.160		0.152	0.153	0 151	0.149	0,150
AJ	2.518	2.538		2.525	2.525	2 57	8 2.518	2.52
AK	0.040	0.060		0.048	0.048	2.57	7 .049	0.04
AL	0.010	0.020		0.012	0.012		2 0.012	0.01
AM	0.140	0.160		0.012	0.149	0.15	3 0.155	0.15
AN	0.350	0.450		0.375	0.385	2.39		0.38
AO	0.240	0.260		0.250	0.250	0.25	0 0.250	
AP	0.150	0.170		0.154	0.151	0.149	15 0.131	0.505
AQ	0.053	0.073		0.060	0.0G	0.06		0.06
AR	101.64	105.64		103.64	103.64	103,0		1 103.6
AS	0.260	0.267		0.260	0.260	0.26		
AT	0.053	0.073		0.063		0.00		0.06
AU	4.118	4.138		4.128	4.129	410		
AV	4.110	4.100		1.180	1	1		
AW								
***		1	Accept/Reject					
		11 11 4				l Da	ite: 08/	08/02
	Measure	by: M.A				Da	ite.	00/02
	Audite	d by: 3				Da	ite: 08/0	58/05
Proto	type Appr	oval				Da	ite:	/
1010	rype Appr	oval.						
Rev	Date	Change					Revised by	Approve
Α	02.12.12	New Issue					KJ/RF	
В	07.05.08	Dwg Rev. up	dated				KJ/JLM	
С	07.07.18	Dimension A					KJ/JLM A	21

THE REPORT OF THE PERSON OF TH		
DART AEROSPACE LTD	Work Order:	59085
Description: Ø3.250 Support	Part Number:	D2940-1
Inspection Dwg: D2940 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

			X First A	rticle	Proto	type		
	Record Actual Dimensions							
Dim	Min	Max	Go/No Go Gauge	16	77	\$ 8	49	\$ 10
			1	HAAS Section	on			
AA	0.240	0.260		0.250	250	257	0 : 250	.150
AB	0.490	0.510		0.500	. 500	.500	. 500	20C v
AC	0.140	0.160		0.151	.152	.15	2 154	120
AD	3.510	3.530		3.518	3,520	3.570	1 3.52	3.521
AE	1.633	1.673		1,655	1.104-3	1.64	8 1.000	1 660
AF	1.493	1.513		1.503	1.493	1.494		1.508
AG	0.040	0.060		0.0525	.048	.050	1,648	0045
AH	0.188	0.193		0,188	-188	88	6188	-188
Al	0.140	0.160		0. 151	149	148		2158
AJ	2.518	2.538		2,523	2.528	2.52	8 2528	
AK	0.040	0.060		0.047	.049	,057	2000	3098
AL	0.010	0.020		0.012	-015	615	2015	1015
AM	0.140	0.160		0.153	145	-143	:150	CHIC
	0.350	0.450		0.390	380	370		384
AN	0.350	0.260		0,250	-250	.257		.350
	0.240	0.200		0.1525	.154	154		154
AP	0.150	0.170		0.060	063	.063	-063	.063
AQ		105.64		103.64	103-64	103.60		103.64
AR	101.64	0.267		0.260	.260	-260	1960	1,760
AS	0.260			0,260	.063	.063		1063
AT	0.053	0.073		0.063		4.130	861.4	4,128
AU	4.118	4.138		4-123	4.126	7.150	9,130	131340
AV					-			
AW			Accept/Reject	1			2	
			Accepureject				77.	
Measured by:						Dat	te:	
		00					111	3 20
	Audite	d by: S				Dat	te: 08/08/0	05
Proto	otype Appr	oval:			1	Dat	te:	
D	Date	Change	2				Revised by	Approved
Rev	02.12.12	New Issue					KJ/RF	
A		Dwg Rev. up	datad				KJ/JLM	
В	07.05.08	Dimension A					KJ/JLM 1.A	1
C	07.07.18	Reformat	o revised				KJ/JLM A	111